

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020273**Date Inspected:** 11-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 11, WEST TOWER LIFT 5, GRILLAGE PLATE (NWIT # 06917)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WSD1-TL5-4B/F-023

WSD1-TL5-4E/F-008A/B, 009A/B, 024A/B, 025A/B, 005A/B, 012A/B, 021A/B, 028A/B

WSD1-TL5-4E/F-008A/B, 009A/B, 005A/B, 012A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10, OBG BIKE PATH

During random in process inspection of Orthotropic Box Girder (OBG) member identified as deck plate this QA observed an arc strike on Piece Mark (PCMK) identified as BK004A-031. This QA marked the affected area and

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informed ZPMC Quality Control (QC) indentified as Mr. Li Peng Fei of this issue. Mr. Li Peng Fei informed this QA that the arc strike would be corrected in a manner compliant with the contract documents.

FCAW welding of weld joints 051 located on BK004A3-031.

Welders are identified as 057180 & 040302. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 014 located on BK004A7-031.

Welders are identified as 053869 & 052075. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joints 015 located on BK004A4-031.

Welders are identified as 057180 & 040302. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

BAY 11, OBG BIKE PATH

SMAW welding of weld joint 004 & 127 located on BK004A8-018.

Welder is identified as 040655. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

FCAW welding of weld joints 036& 024 located on BK004A8-018.

Welder is identified as 040759. ZPMC QC is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer